Claims

1. Process for the manufacturing of frozen aerated products comprising;

- providing two separate forming elements,
- providing at least one open cavity on a surface of each forming element,
- providing filling devices for filling said cavities with a frozen aerated material,
- filling two cavities, one on each forming element, with a frozen aerated material,

wherein

a. at least one of the cavities is filled with a frozen aerated product having an overrun of between 30% and 130%,
b. this product is then allowed to expand outside its cavity,
c. the two cavities are then moved opposite one another and the frozen aerated product in each cavity is pressed against the frozen aerated product in the other cavity.

2. Process according to claim 1 wherein the frozen aerated product is at a temperature of between -3°C and -20°C, preferably between -5°C and -15°C, even more preferably between -7 and -11°C, when filled unto the cavities.

3. Process according to claim 2 wherein the two separate forming elements are a pair of parallel rollers wherein each roller has a multiplicity of open cavities on its surface, the rollers counter-rotating so that respective cavities in the two forming elements lie opposite one another and the frozen aerated product in a cavity of a first roller is pressed against the frozen aerated product in an opposite cavity of a second roller.

4. Process according to claim 3 wherein the rollers counter rotate at a variable rational speed.

5. Process according to claim 4 wherein the rotational speed of a roller is at its minimal value when a filling device is over a cavity of this roller and at a maximal value when a filling device is between two cavities.

6. Process according to claim 5 wherein a roller is brought to stop when a filling device is over a cavity.

7. Process according to claim 4 wherein the rotational speed of each roller is at its minimal value when a filled cavity of one roller faces a filled cavity of the other roller.

8. Process according to claim 7 wherein both rollers are brought to stop when a filled cavity of one roller faces a filled cavity of the other roller.

9. Process according to claims 5 and 7 wherein a minimal rotational speed of both rollers is reached when, at the same time, two filled cavities face each other and each filling device is over a cavity of each roller.

10. Process according to claims 6 and 8 wherein each roller is brought to a stop when, at the same time, two filled cavities face each other and each filling device is over a cavity of each roller.